

Work Order ID 53585




November 9, 2009 11:21:15 AM



Page 1

Item ID:	D3463-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Step Weldment Assembly					
Start Date:	09/11/2009	Start Qty:	4.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	09-11-9	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3463	Rev B								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3463 using DT8875								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									
120	✓ QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

EL/SP

9-11-11

X

RD

09.11.11

9

4

EL/SP 9-11-11 (X4)

RD 09.11.11 (9)

4 [Signature]

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Item ID: D3463-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Weldment Assembly

Start Date: 09/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3,5.2) per QSI005 4.3-Steel

11/12/48

0.00

⇒ JY 09/11/12

(X4)

Ø

Memo

0.00

1- Mask areas indicated on dwg D3463 (holes, threads) □ START

TIME: 7:00AM □ OVEN TEMPERATURE:

7:30AM □ FINISH TIME:

400°F

140



HandFinish

Hand Finishing

~~Pressure Wash per QSI005 4.3~~

Wing walk as per

Memo

Dwg 4 QSI005

0.00

⇒ JY 09/11/12

(X4)

Ø

0.00

09.11.13

11/12623

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

⇒ JY 09-11-13

(4)

0.00

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Item ID: D3463-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Weldment Assembly

Start Date: 09/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

9/11/13 (4) 50

09/11/16

MF
09-11-16

Picklist Print

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Work Order ID: 53585



Parent Item: D3463-041RevB



Parent Item Name: Step Weldment Assembly

Start Date: 09/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
238-806 SS DOWEL PIN 1" LONG		Purchased	No			100	Each	96.0000	8.0000			

EL 9-11-10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 96
105037 3
111088 89
19080 4

D3453-3RevB 	Manufactured	No				100	Each	0.0000	4.0000			
-----------------	--------------	----	--	--	--	-----	------	--------	--------	--	--	--

2x46150
2x46262

EL 9-11-10

Clevis D3453-5RevB 	Manufactured	No				100	Each	10.0000	4.0000			
---------------------------	--------------	----	--	--	--	-----	------	---------	--------	--	--	--

EL 9-11-10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 10
52985 10

D3463-1RevB 	Manufactured	No				100	Each	18.0000	4.0000			
-----------------	--------------	----	--	--	--	-----	------	---------	--------	--	--	--

EL 9-11-10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 18
46148 18

4

Picklist Print

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Work Order ID: 53585

Parent Item: D3463-041RevB

Parent Item Name: Step Weldment Assembly



Comments:

Start Date: 09/11/2009

Required Date: 13/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3463-3RevB		Manufactured	No			100	Each	76.0000	4.0000			
												
Step												

EL 9-11-10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

76

44606

1

46149

24

46269

51

4

D3463-5RevB

Manufactured No

100

Each

37.0000

8.0000



EL 9-11-10

End Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37

46270

37

8

D3463-7RevB

Manufactured No

100

Each

12.0000

4.0000



EL 9-11-10

Drag Arm

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

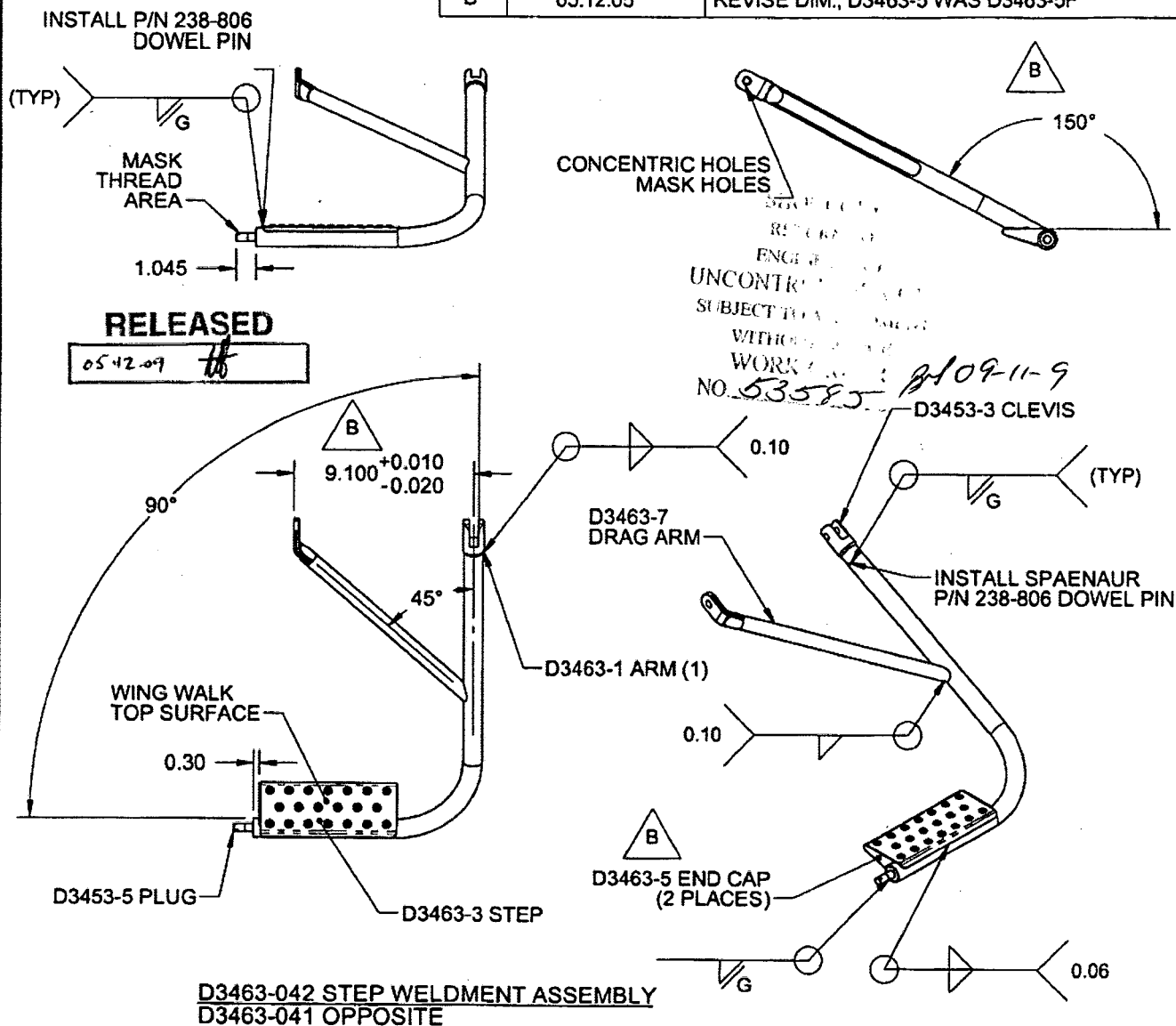
46271

12

4

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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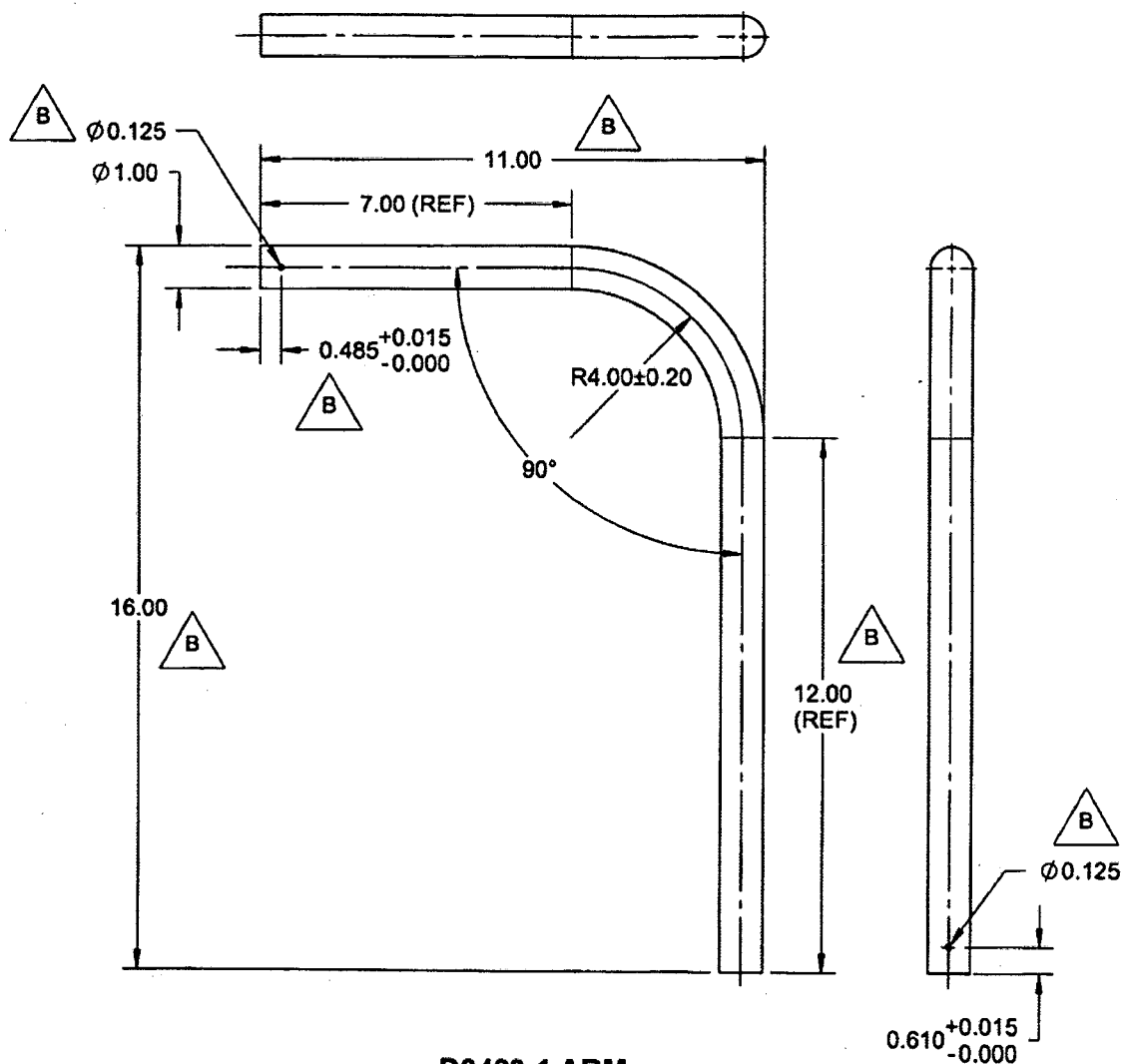


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09

w/o 53585



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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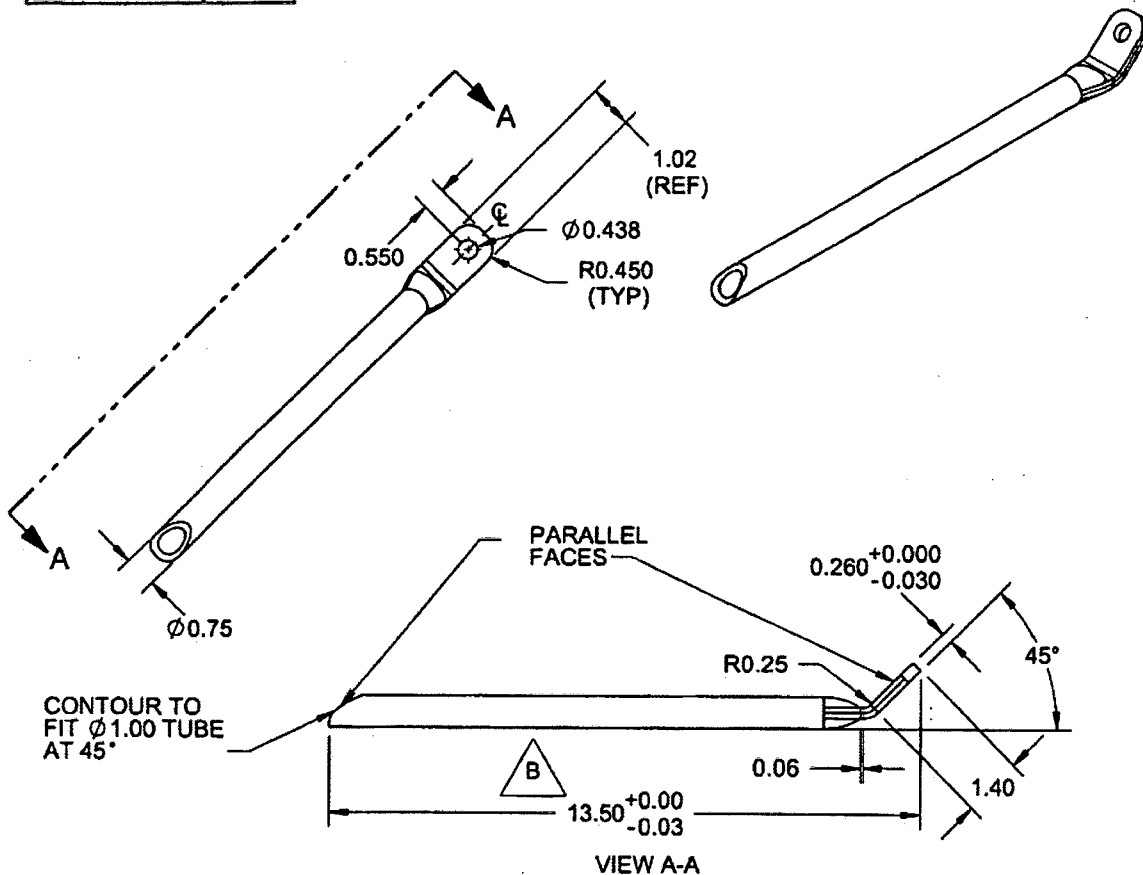
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05 #

w/o 53595

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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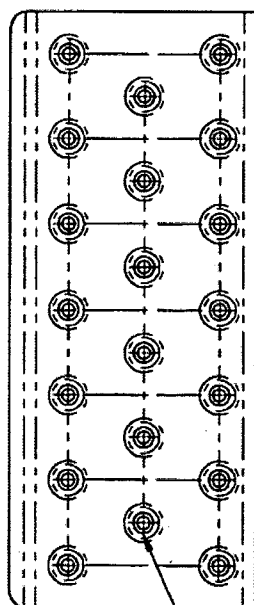


W/6 53585

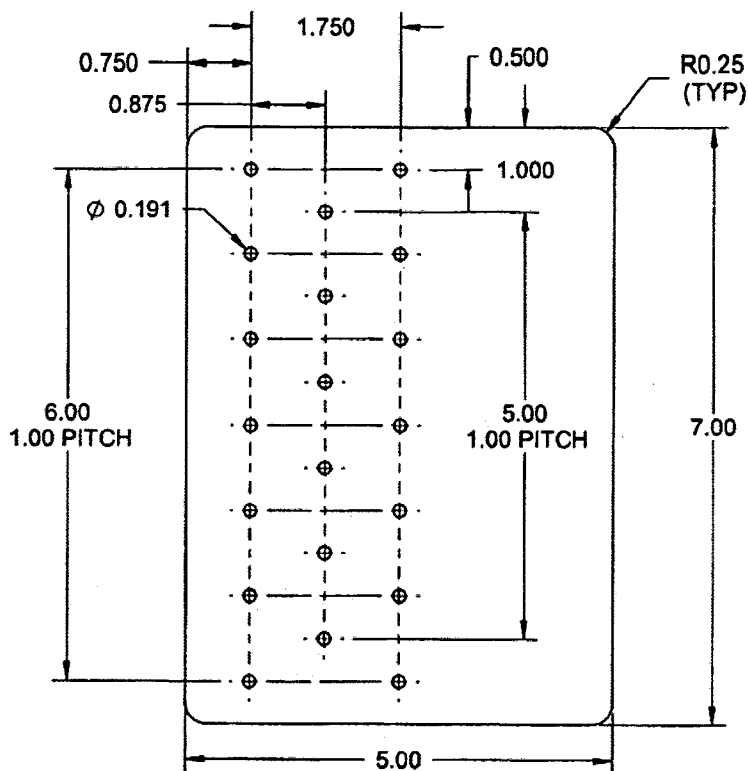
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

RELEASED

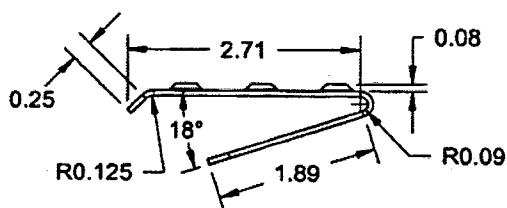
05.12.09 #



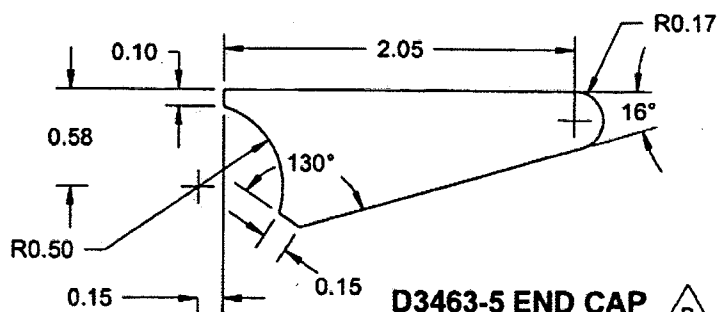
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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